

**Work Order ID 105474****\*105474\***

Page 1

Tuesday, August 06, 2013 12:55:14 PM

Item ID: D6202

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: I-Beam Extrusion

Start Date: 8/6/2013 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 8/13/2013 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals: Process Plan: CL Date: 13/08/06 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D6202

Rev A

100

0.00

**\*100\***

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 20861

a) Description: American standard I-beam 4.000" x 2.796" x 0.326" thick

b) Material: 6061-T6/T651 (QQ-A-200/8)

c) Minimum ultimate tensile strenght = 38 ksi

d) Minimum yield tensile strenght = 35 ksi

e) Material cert"s is required

\*\*\*EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE  
SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH  
AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS,  
OR DENTS.\*\*\*

\*\*\*MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE\*\*\*

CL 13/08/08 (25)

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>						
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector			
Doc/Data <input type="checkbox"/>												
Equip/Tooling <input type="checkbox"/>												
Operator <input type="checkbox"/>												
Material <input type="checkbox"/>												
Setup <input type="checkbox"/>												
Other <input type="checkbox"/>												
Process <input type="checkbox"/>												
Supplier <input type="checkbox"/>												
Training <input type="checkbox"/>												
Unapproved <input type="checkbox"/>												
<b>FAULT CATEGORY</b>												
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other	

Tuesday, August 06, 2013 12:55:14 PM

**Item ID:** D6202

**Accept**

\*N900040100\*

**Setup Start**

**\*NS1\***

Revision ID:

Stop \*NS2\*

**Item Name:** I-Beam Extrusion

**Start Date:** 8/6/2013      **Start Qty:** 20.00

**\*20\***

**Cust Item ID:**

**Required Date: 8/13/2013      Req'd Qty: 20.00**

\*20\*

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:** \_\_\_\_\_ **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110

Receive & Inspect for Damage & Mat'l Certs

0.00

**\*110\***

0.00

### Packaging

## Memo

### Packaging

Ensure material certification is attached

120

QC6- Inspect dimensions to drawing

0.00

\*120\*

0.00

QC

## Memo

## Quality Control

Ensure Material certification comply to Dwg D6202

130

Identify as per dwg & Stock Location: PLF 28 0.00

0.00

\*130\*

0.00

### Packaging

## Memo

## Packaging

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>					
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Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											

FAULT CATEGORY				
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other

Work Order ID 105474

\*105474\*

Page 3

Tuesday, August 06, 2013 12:55:14 PM

Item ID: D6202

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: I-Beam Extrusion

Start Date: 8/6/2013 Start Qty: 20.00

\*20\*

Cust Item ID:

Required Date: 8/13/2013 Req'd Qty: 20.00

\*20\*

Customer:

Reference:

Run Start

\*NR1\*

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop

\*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC21- Final Inspection - Work Order Release	0.00							
*140*									
QC	Memo	0.00							
Quality Control									

MLJ 13-08-21  
MLJ 13-08-19

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

<b>Work Order:</b> _____  <b>Part No.</b> _____  <b>NCR No.</b> _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

**FAULT CATEGORY**

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Picklist Print

Page 1

Tuesday, August 06, 2013 12:55:14 PM

Work Order ID: 105474

Parent Item: D6202

Parent Item Name: I-Beam Extrusion

Start Date: 8/6/2013

Required Date: 8/13/2013

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A: 01.04.19New Issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6202P		Purchased	No			110	f	0.0000	1	20			
1 Beam Extrusion													

20 x 8-13-19

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											

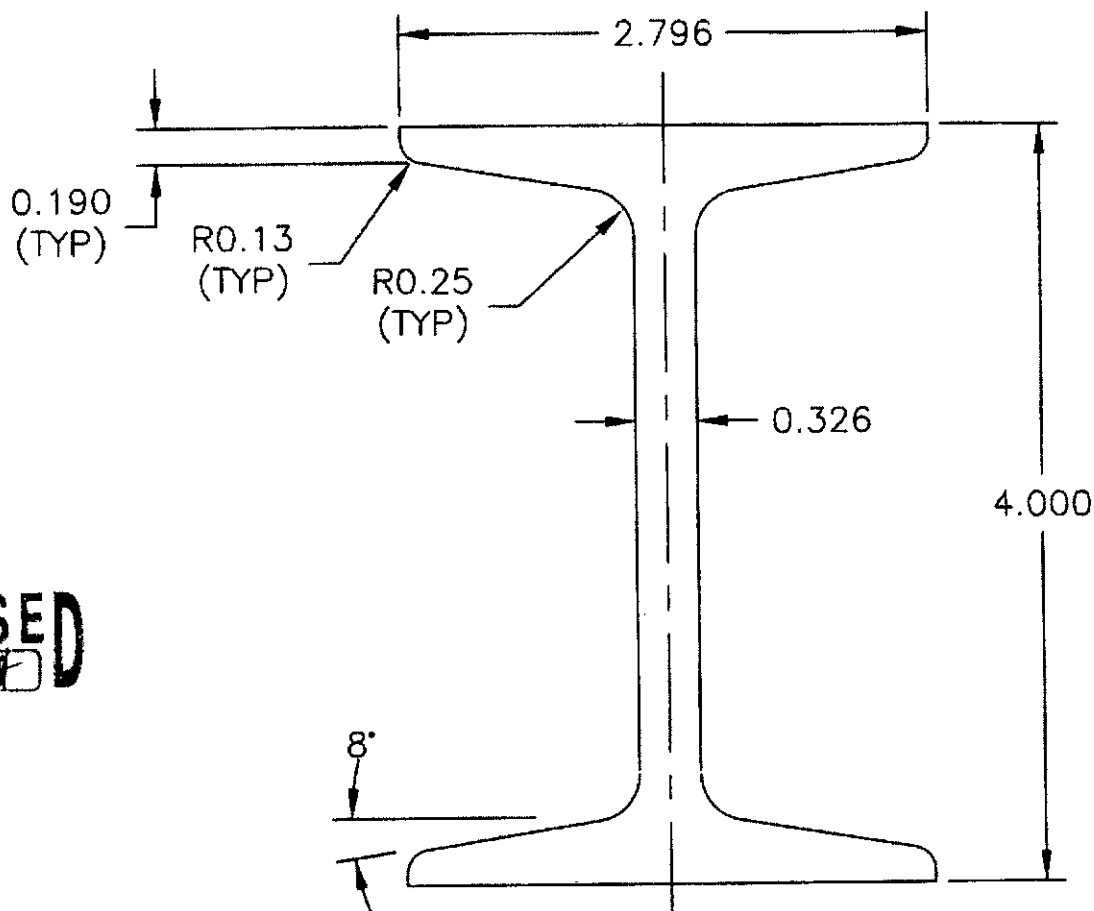
FAULT CATEGORY				
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other





DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D6202	REV: A SHEET 1 OF 1
DATE 01.04.02		TITLE I-BEAM EXTRUSION	SCALE 1:1
A	01.04.02	NEW ISSUE	

## SPECIFICATION CONTROL DRAWING



**RELEASED**  
01.04.02

D6202-XXX I-BEAM EXTRUSION  
WHERE XXX IS LENGTH IN INCHES

EG.  
D6202-027 IS 27 INCHES LONG

PURCHASE MATERIAL: AMERICAN STD. I-BEAM  
4.000" x 2.796" x 0.326" THICK  
6061-T6/T651 (QQ-A-200/8)  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi  
MINIMUM YIELD TENSILE STRENGTH = 35 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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NCR: Yes / No (

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

**FAULT CATEGORY**

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

# RYERSON

## Shipping Order / Bordereau d'expédition

MO # 200 RUE DU CHEMINOT VAUDREUIL-DORION QC J7V 5V5  
200 RUE DU CHEMINOT VAUDREUIL QC J7V 5V5  
Phone/Tel (450) 424-0153

Page 1 de 1 08/16/13 07:20 CST  
SO AP  
R Entree/Sortie

Sold to/Facteur a: DART AEROSPACE LTD.  
1270, ABERDEEN STREET

Ship to/Expedier a: DART AEROSPACE LTD.  
1270, ABERDEEN STREET

# de bon de commande associé: 74074

S.O. / Bordereau d'expédition
<b>X6-313758</b>
P.O. / Bon de commande
20861

HAWKESBURY ON K6A 1K7 HAWKESBURY ON K6A 1K7 Phone/Tel (613) 632-3336

**Total Packages /  
Paquets totaux 1**

Ship Via / Expédier par	Freight / Fret	Customer # / # Client	Sales / Ventes	Tax Status / Statut fisca	Contact / Personne ressource	Certs	Due Date / Date due
Ontario	Ntr camion PP/tous	1946	21 EB	Imposbl		1	08/19/2013
Bill of Lading / N° du connaissance	Pro Bill / Bordereau d'envoi	Ship Approval / Approbation de l'expédition		Ship Date / Date d'expédition		Order Date / Date de commande	
						08/09/2013	

Line / # de ligne    Item    Description    Qty Shipped/Qté expédiée    B.O.Qty/En souffrance

1    5100-0008 I-BEAM 6061-T6 4 X .326 X 25'  
Order Qty/Qté commandée    1    UEA    Pcs: 1    1.00 UEA  
(1 LENGTH 81 )  
Cntrl: X6FN4543 C: 201305625    T: 740745    1 pcs Loc EXP  
\*\*\* Filled by Initials/Rempli par initiale: LM

2    7915-9998 ENERGY CHARGE  
Order Qty/Qté commandée    1.0000 LOT    Pcs: 0    1.00 LOT

13/08/13

88.13-8-19

Customer/Driver Instructions / Commentaires du client/chauffeur:  
HEURES D'OUVERTURE 7H @ 16H LUN @ VEND DECHARGEMENT AU CHARIOT ELEVATEUR AVANT COTE CHAUFFEUR  
CFC ET MTR REQUIS A LA LIVRAISON

Received by/ Reçu Par: \_\_\_\_\_ Date: \_\_\_\_\_  
Acceptance of goods constitutes acceptance of our Terms and Conditions, available on our website at [www.Ryerson.com](http://www.Ryerson.com),  
or from your sales representative, or by calling (800) 268-2680.  
L'acceptation des marchandises constitue un consentement à nos termes et conditions, qui sont disponibles  
sur notre site web [www.ryerson.com](http://www.ryerson.com), ou par votre représentant interne, ou par téléphone (800) 268-2680.

Packing List/Bordereau de marchandises

Alloys of Aluminum, Copper, Steel **Caution:**  
Processing of this material may present a physical and or health hazard. See material safety data sheets for further information  
Les alliages d'aluminium, de cuivre, d'acier **Avertissement:**  
Le Traitement de ce matériel peut présenter un risque physique et ou pour la santé. Pour de plus ample information voir les fiches.





**SERVICE CENTER METALS**  
5850 Quality Way  
Prince George, VA 23875

# **CERTIFIED INSPECTION REPORT AND TEST RESULTS FOR EXTRUDED PRODUCTS**

BILL TO <b>YARDE METALS</b>		MANIFEST NUMBER <b>185496</b>	DIE NUMBER <b>BS0291</b>	DATE OF SHIPMENT <b>3/26/2013</b>	OUR ORDER NUMBER <b>169137</b>	ITEM <b>7</b>
SHIP TO <b>YARDE METALS-Southington CT</b>		CUSTOMER PO <b>P30206CG014 CT</b>	ALLOY/TEMPER <b>6061-T6</b>	SALESPERSON <b>Ellis Williams</b>	CERTIFICATION <b>ASTM-B308-10 SPOT STENCIL</b>	
Quantity Certified	2,053 lbs	25 pcs	CUSTOMER PART NUMBER <b>BS0291</b>	DESCRIPTION <b>ASI 4.000x2.796x.326</b>	SPECIFICATION <b>ASTM-B221-12a</b>	
<p><i>We hereby certify that the material covered by this report has been inspected in accordance with the most recent certification revision, and has been found to meet the applicable requirements described herein, including any specifications forming a part of the description, and that samples representative of the material met the composition limits and had the mechanical properties shown.</i></p> <p>SCM extrusions are manufactured in the USA.</p>					SPECIFICATION <b>AMS-QQA-200/8</b>	
					SPECIFICATION <b>AMS-QQA-200/16</b>	

Mechanical Properties		Test Date	Ultimate Tensile Strength (KSI)	Yield Strength (KSI)	Percent Elongation
Tests	Lot No.				
1	201305323	03/20/13	43.4	41.4	11.9
1	201305626	03/21/13	45.1	42.8	11.3

YARDE METALS, INC. CERTIFIES THAT  
THIS IS A TRUE COPY OF THE ORIGINAL  
MILL TEST REPORT NOW ON FILE.  
RECEIVED AND INSPECTED

**MAR 27 2013**

BY   
Ryan McDonald, Certification Processor

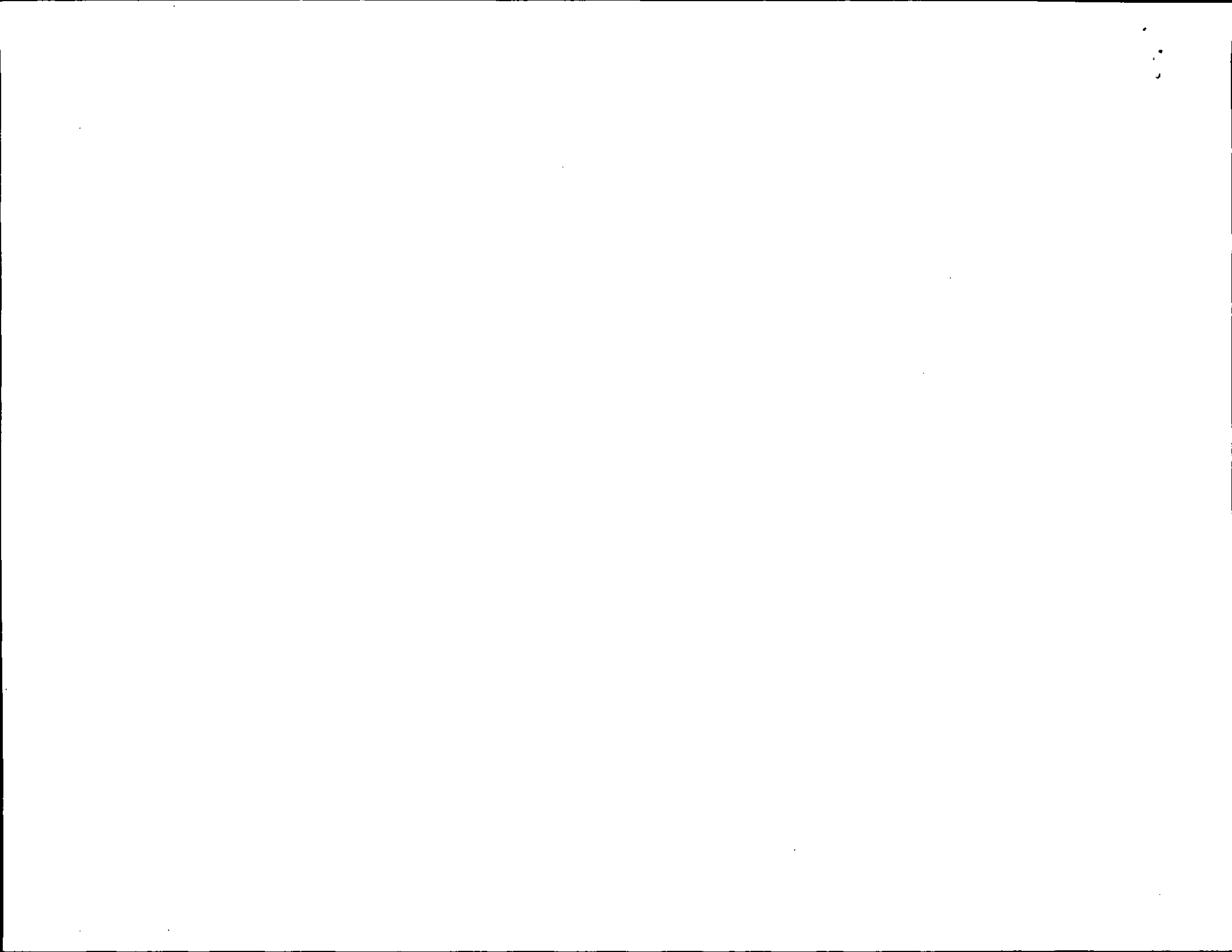
## **Chemical Composition for Aluminum Alloy 6061**

Cast Number	Alloy	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Al	Others		Melt Source:
											Each	Total	
C67R0410	6061	0.63	0.17	0.17	0.02	0.85	0.06	0.01	0.01	98.08	0.05	0.15	United States of America
C67R0412	6061	0.61	0.15	0.17	0.01	0.84	0.06	0.01	0.01	98.14	0.05	0.15	United States of America

Print Date: 3/26/2013

Calvin J. Wiggins, Director of Quality & Technical Services

Rev. 9/23/11 - UMS





Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

# PURCHASE ORDER

Purchase Order ID **PO20861**

Purchase Order Date 8/8/2013

PO Print Date 8/8/2013

Page Number 1 of 1

**Order From :**

VC-RYS001

RYERSON  
200 DU CHEMINOT  
VAUDREUIL, QUEBEC J7V 5V5

**Ship To :** DART AEROSPACE LTD  
1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**FAKED**  
08/30/2013

**Contact Name**

**Vendor Phone** 450-424-0153

**Ship To Contact**

**Ship To Phone**

**Ship Via:** Yours ppd

**Ship Acct:**

**Buyer**

Chantal Lavoie

**Customer POID**

**Customer Tax #** 10127-2607

**Terms**

Net 30

**Currency**

CAD

**FOB**

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extende Pric
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1	M304S22GA4P	304/316 Sheet .032	8/12/2013 Yes 8/12/2013		128.00 sf	\$2.97	\$380.00
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MATERIAL: AISI 304/316 SS SHEET ANNEALED AS PER  
MIL-S-5059 OR AMS 5513 (304) AMS 5524 (316) ASTM A240 OR ASME SA240  
POLISH NO.4

8/13-8-12

**Line Total:** \$380.00

2	D6202P	I Beam Extrusion	8/20/2013 Yes 8/20/2013		20.00 f	\$39.75	\$795.00
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AS PER DWG D6202 REV. A B105474  
B105474

8/13-8-19

**Line Total:** \$795.00

**PO Total:** \$1,175.06

Note: Pricing listed above is as per contract agreement between Dart Aerospace and the respective manufacturer.  
No substitution or deviation without consent.  
Certificate of Conformity or Material Certification required - YES NO  
PST# 6122-5207

Change Nbr:

2

Change Date:

8/8/2013

